

Date: Monday, 6/12/2006 3:49:02 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 27529	
Estimate Number : 10554	
P.O. Number : <u>NIA</u>	Part Number : D34431
This Issue : 6/12/2006 S.O. No. : <u>NIA</u>	Drawing Number : D3443 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>NIA</u> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 25519	Material : <u>NIA</u>
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 6/19/2006
Checked & Approved By : <u>06.06.13</u>	Qty: 4 Um: Each
Comment : A 05.11.14 New issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B2500X1250	17-4 SS BAR
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Comment: Qty.: 0.2100 f(s)/Unit Total : 0.8400 f(s)  
 Material: 17-4 SS Bar 2.500" X 1.250"  
 (M17-4-B2.500x01.250)  
 Batch: M18744

J.L 06/06/21

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blank 2.400 " long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA587 Rev: A & Dwg D3443 Rev: B

SA 06.06.22

(4)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.06.22

(4)

5.0	QC8	SECOND CHECK
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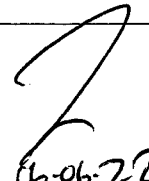

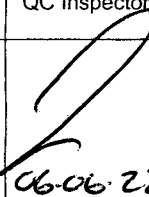



Comment: SECOND CHECK

J.G 06/06/03

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
060621	3.0	- part scrap dimension .342 +0 -.005 is under tolerance too .324		Scrap in place destroy.	SL 06/06/21	 06-06-22	 06/06/22	 06-06-22

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/06/27

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/12/2006 3:49:02 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 27529

Part Number: D34431

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
Tumble & deburr per dwg D3443

3L 06/06/26

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

26.06.26 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ST436

AL 06/06/26 (4)

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

06/06/27 (4)

Job Completion



06.06.27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

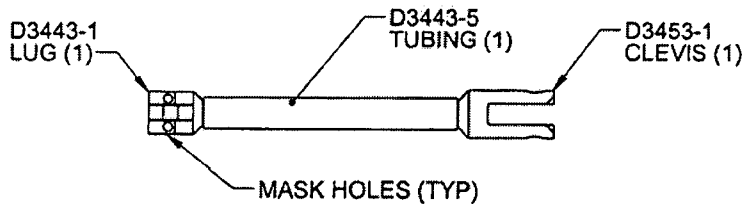
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

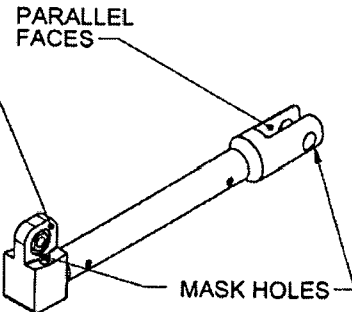
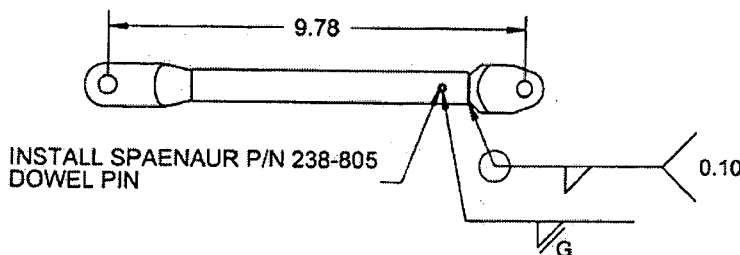
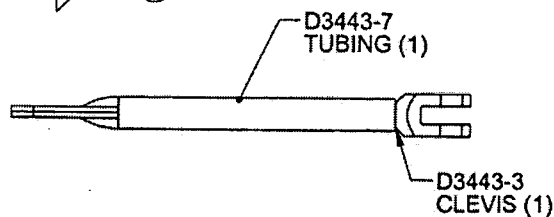
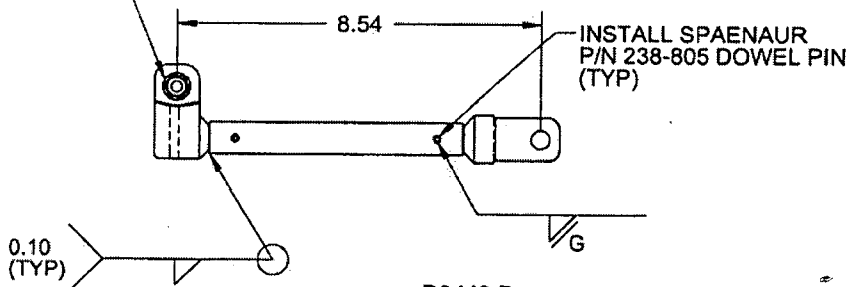
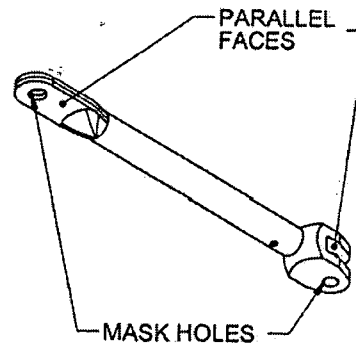
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3443</b>	REV. B SHEET 1 OF 3
DATE <b>05.12.05</b>	TITLE <b>STRUT WELDMENT ASSEMBLY</b> SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

**RELEASED**05.12.09 *H*

PRESS FIT McMASTER-CARR P/N 63215K32  
BALL JOINT BEARING AFTER POWDER COAT

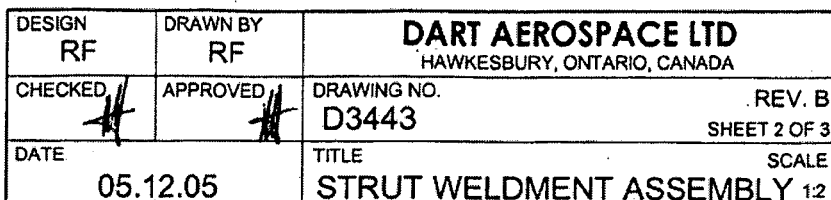
**D3443-041****D3443-043****NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

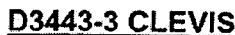
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- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



- D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

**GENERAL NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

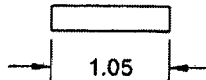
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**DART**

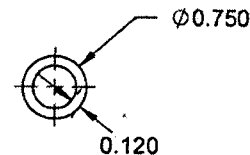
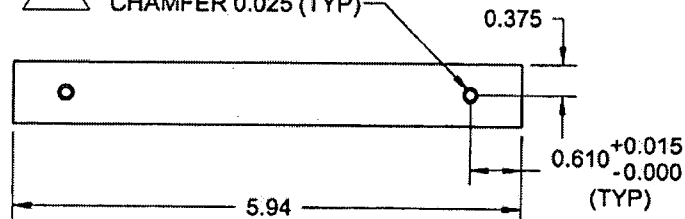
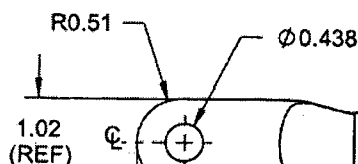
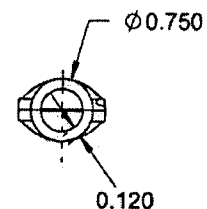
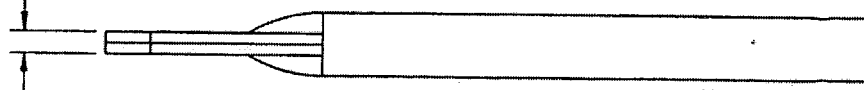
DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

 $\phi 0.210^{+0.005}_{-0.010}$ **D3443-9 PIN****D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

**RELEASED**

05.12.09

DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025 (TYP)**D3443-5 TUBING** $0.260^{+0.000}_{-0.030}$ DRILL  $\phi 0.125$  THRU  
CHAMFER 0.025

0.375

 $0.610^{+0.015}_{-0.000}$ **D3443-7 TUBING****D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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DART AEROSPACE LTD		Work Order: 27529
Description: <i>Start weldment assembly</i>		Part Number: D3443-1
Inspection Dwg: D3443, Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+ .010	1.000	✓			
.342	+ .005	.340	✓			
.329	+ .010	.330	✓			
Ø .500	+ .005	.499	✓			
2.21	+ .030	2.212	✓			
.625	+ .010	.627	✓			
.95	± .030	.950	✓			
2.23	"	2.231	✓			
.229	+ .010	.231	✓			
.525	+ .010	.525	✓			
.370	"	.370	✓			
1.048	"	1.047	✓			
.390	"	.389	✓			
.524	"	.524	✓			
Ø .656	+ .001	.655	✓			
470	± .01	473	✓			
.165	± .01	.165	✓			
<i>[Signature]</i>						

Measured by: <i>J.L. / SD</i>	Audited by: <i>BG</i>	Prototype Approval: <i>N/A</i>
Date: <i>06/06/21/060622</i>	Date: <i>06.06.22</i>	Date: <i>N/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	